

Work Order ID 54329 - 2

Split



Page 1

December 8, 2009 8:45:05 AM

Item ID: D3783-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lateral Brace Assembly

16

Start Date: 08/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date: 07/12/08

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3783

Rev A

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-assemble as per dwg D3783

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 8106105

416

p

Pto ->

EP50/01/05 (16)

EP10/01/05 (16)

Dart Aerospace Ltd

W/O: 54329

Perm. change

10/01/07

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/01/05	# 30	Powder coat Per Q32005 (mask inside D3765-1 clews) Grey M112588 START: 10:30am Temp: 320°F FIN: 11:00am	gfg	10-01-06	(16)		S 10/01/05
10/01/05	# 140	inspect Powder coat Qc 3	BR	10-01-06	(16)		S 10/01/05

Part No: D3783-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150 150



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

160 160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

14/01/07 *(15)*

10/01/07 *[Signature]*

MF 10-01-07

Picklist Print

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Page 1

Work Order ID: 54329

Parent Item: D3783-041

Parent Item Name: Lateral Brace Assembly

Comments:

Start Date: 08/12/2009

Required Date: 16/12/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN5-I3A

Purchased

No

110

Each

252.0000

40.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

252

104936

3

108167

8

110363

14

112492

10

112641

17

113237

200

AN960JD516

Purchased

No

110

Each

976.0000

80.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

976

110363

46

110523

57

111279

39

112082

64

112314

14

112828

256

113149

500

EP 10/01/05

EP 32 10/01/05

EP 64

Picklist Print

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Page 2

Work Order ID: 54329

Parent Item: D3783-041

Parent Item Name: Lateral Brace Assembly




Comments:

Start Date: 08/12/2009

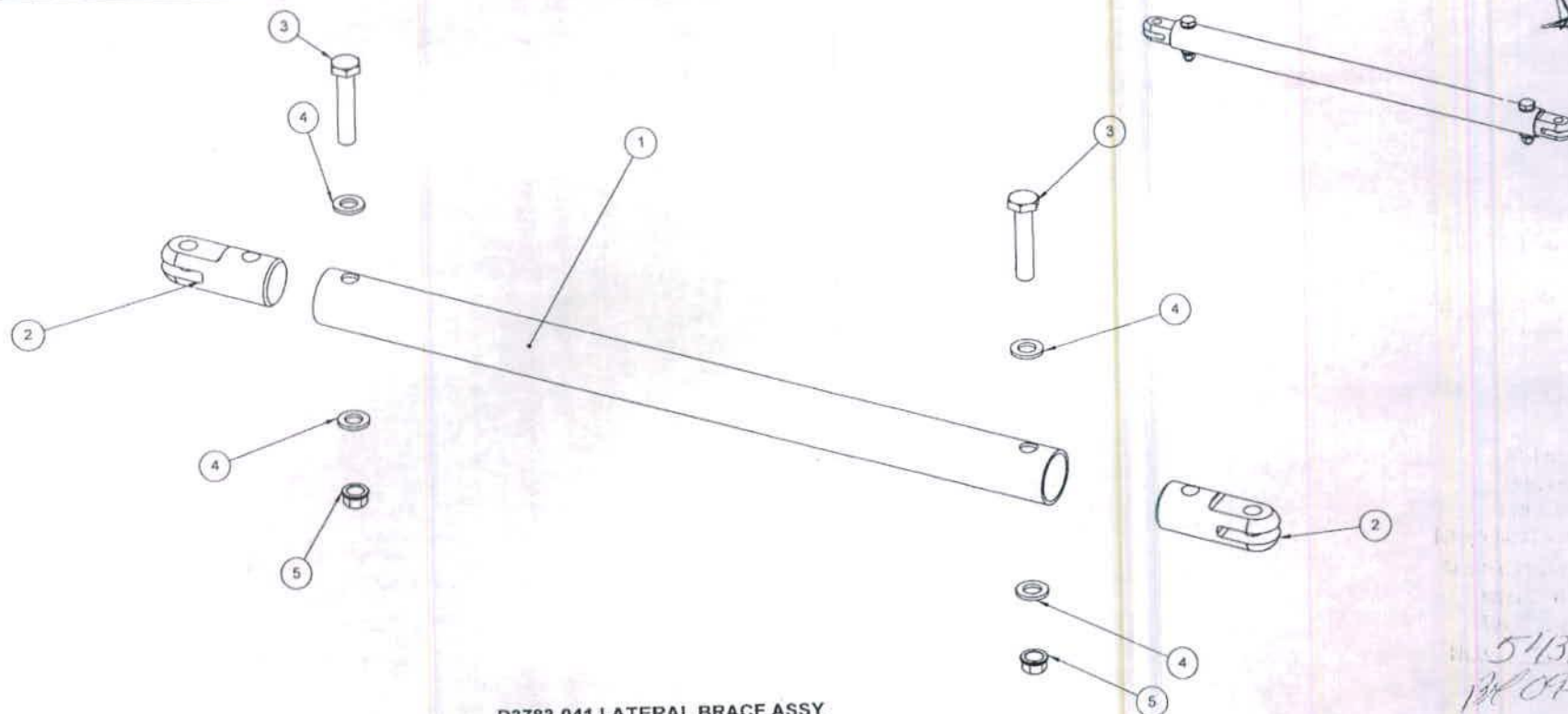
Required Date: 16/12/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3765-1  Clevis		Manufactured	No			110	Each	36.0000	40.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>42766</div>												
<div>Loc Qty</div> <div>36</div>												
<div>Loc Code</div>												
D3769-1  Tube		Manufactured	No			110	Each	5.0000	20.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>42960</div>												
<div>Loc Qty</div> <div>5</div>												
<div>Loc Code</div>												
MS210421.5  Nut		Purchased	No			110	Each	730.0000	40.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>110382</div> <div>111636</div> <div>112314</div>												
<div>Loc Qty</div> <div>730</div> <div>10</div> <div>11</div> <div>709</div>												
<div>Loc Code</div>												

Ep 10/01/05
B54434 (20x)
B54343 (12x)
Ep 10/01/05
11x B54344 (15x)
Ep 10/01/05
32



D3783-041 LATERAL BRACE ASSY

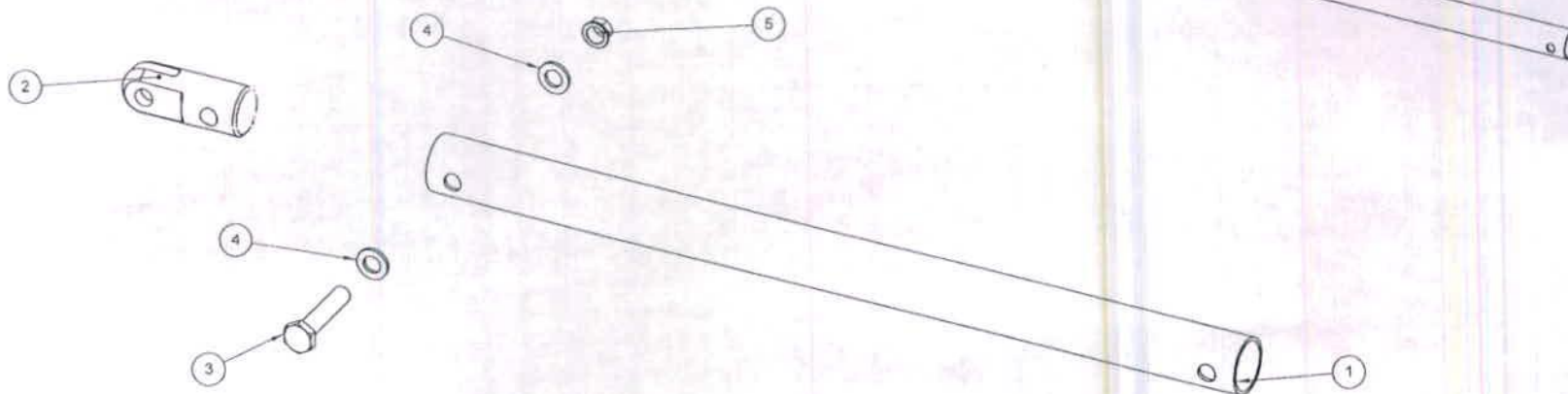
ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3769-1	TUBE	1
2	D3765-1	CLEVIS	2
3	AN5-13A	BOLT	2
4	NAS1149D0568J	WASHER (AN960JD516)	4
5	MS21042L5	NUT	2

RELEASED
08-06-16/17

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.52 lbs

A		NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	HS			
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3783	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		BRACE ASSEMBLY	NTS	
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D3783-043 LONGITUDINAL BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3769-3	TUBE	1
2	D3765-1	CLEVIS	1
3	AN5-13A	BOLT	1
4	NAS1149D0568J	WASHER (AN960JD516)	2
5	MS21042L5	NUT	1

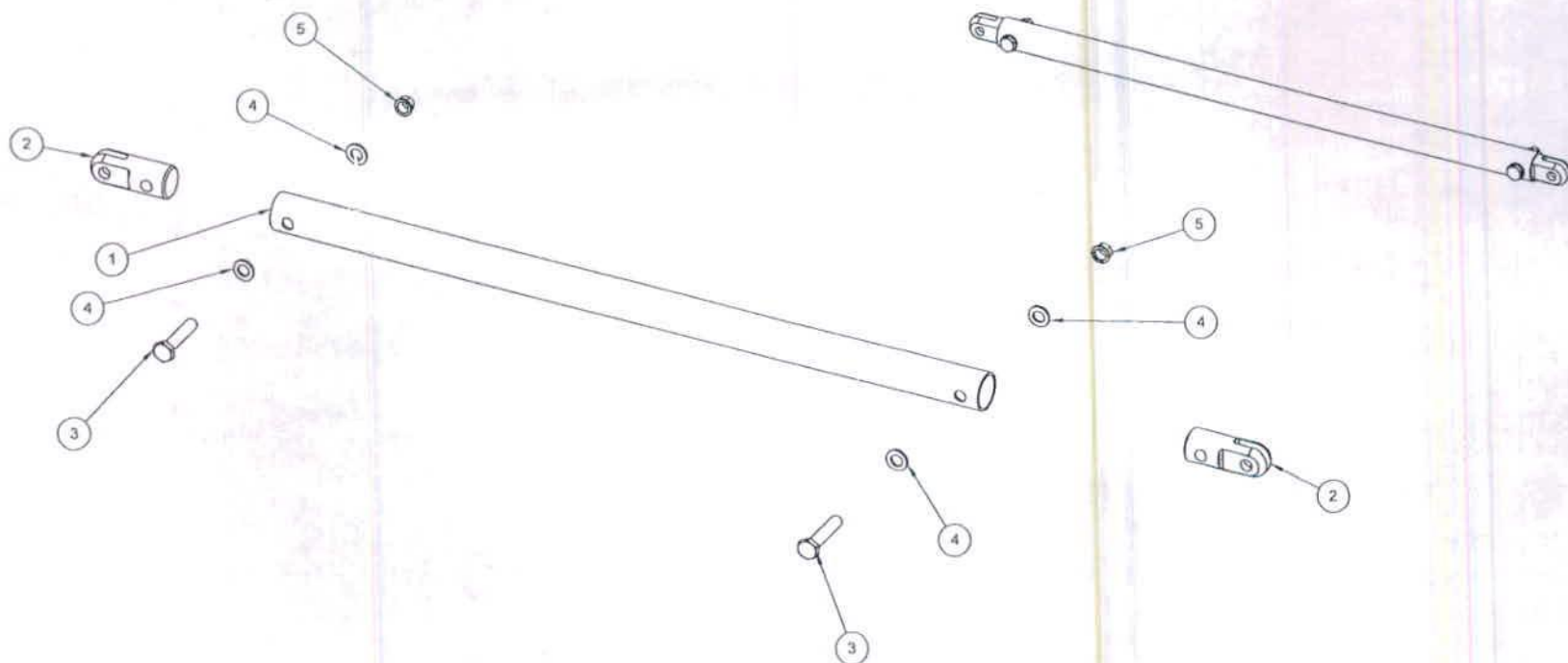
RELEASED
06-06-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs

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TITLE BRACE ASSEMBLY		SHEET 2 OF 3
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W/O 54329



D3783-045 ANGLE BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3769-5	TUBE	1
2	D3765-1	CLEVIS	2
3	AN5-13A	BOLT	2
4	NAS1149D0588J	WASHER (AN960JD516)	4
5	MS21042L5	NUT	2

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.63 lbs

RELEASED
08-06-14

W/O 54329

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